

Work Order ID 112844

February-10-14 8:58:01 AM

112844

Page 1

Item ID: D4541-7

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket

Start Date: 2/10/14

Start Qty: 2.00

2

Cust Item ID:

Required Date: 2/13/14

Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: 

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4541

D

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

1- Cut as per dwg D4541-7F

Prog rev: DDwg rev: D

2- Deburr

0.00

2 0 De
14.02.10

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

2 0 De
14.02.10

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Page 2

Run	Start	*NR1*
	Stop	*NR2*

**Insp.
Stamp**

Quality Control

Bend tabs as per dwg

**DAS
30
9-89**

Quality Control

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Start Qty: 2.00

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Cust Item ID:

Required Date: 2/13/14

Req'd Qty: 2.00

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

144

Chemical Conversion Coat per QSI005 4.1

0.00

144

HandFinish

Memo

0.00

Hand Finishing

146

QC7-Inspect Chemical Conversion Coat

0.00

146

QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: 31525

0.00

150

Packaging

Memo

0.00

Packaging

DAS
27
3-89

14/2/11

2

DAS
28
9-89

2x

14-02-11

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Item ID: D4541-7

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Bracket

Stop ***NS2***

Start Date: 2/10/14

Start Qty: 2.00

2

Cust Item ID:

Required Date: 2/13/14

Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

14-02-12

14-02-12

Picklist Print

February-10-14 8:58:00 AM

Page 1

Work Order ID: 112844

Parent Item: D4541-7

Parent Item Name: Bracket

Start Date: 2/10/14

Required Date: 2/13/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP revA 12.01.04 New Issue EC verified by:DD IPP REV:B 12.02.24 as per dwg
revb DD verf:EC IPP REV:C 12.05.08 as per dwg revC DD verf:EC IPP
REV:D 13.04.23 as per dwg revD DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032 6061-T6 Sheet 0.032"		Purchased	No			100	sf	459.8032	0.258	1		De 14-02-10	

Location

Loc Qty

Loc Code

MAT021

459.80317

123483

8.57

m125822

17

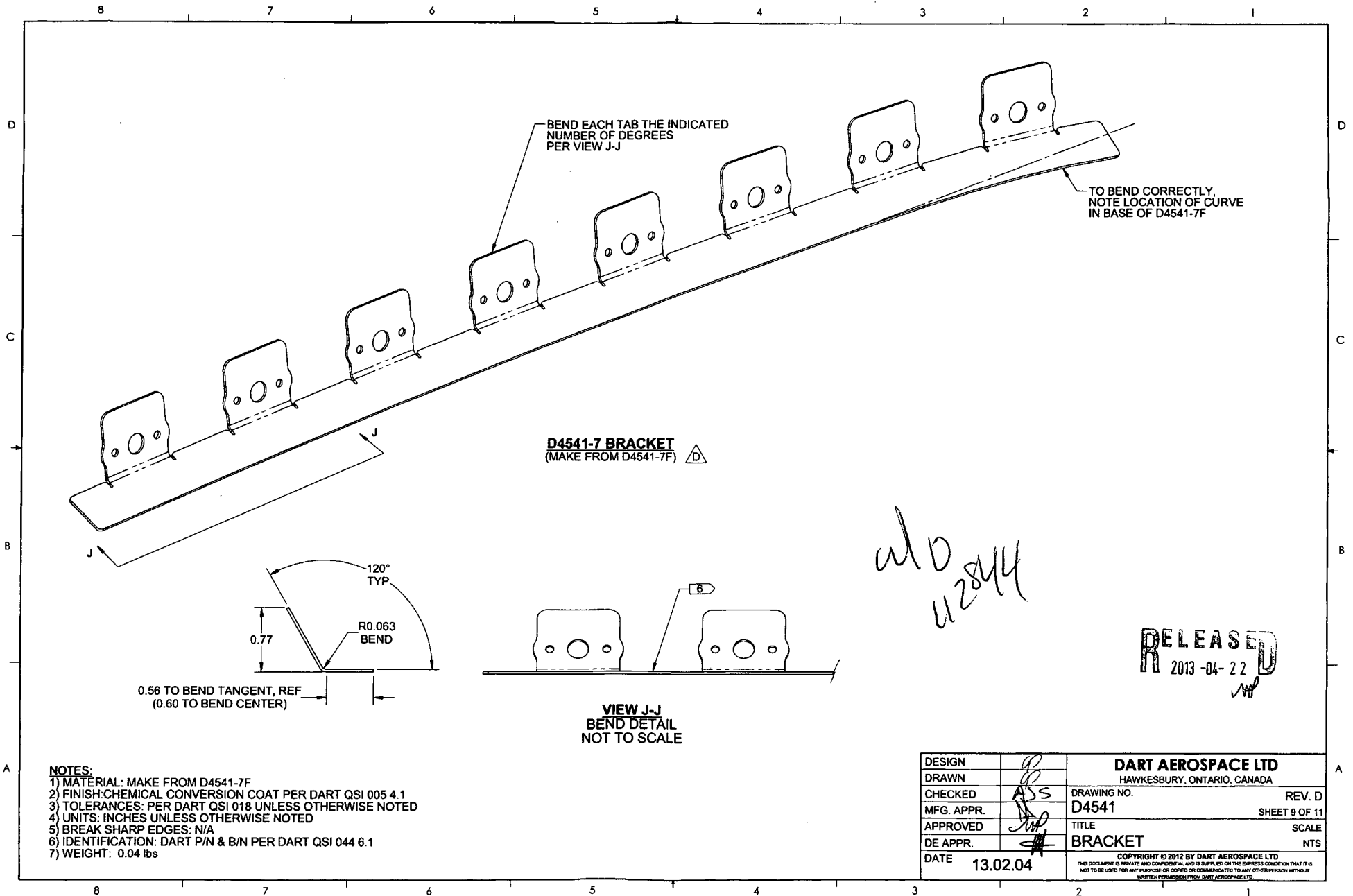
m127272

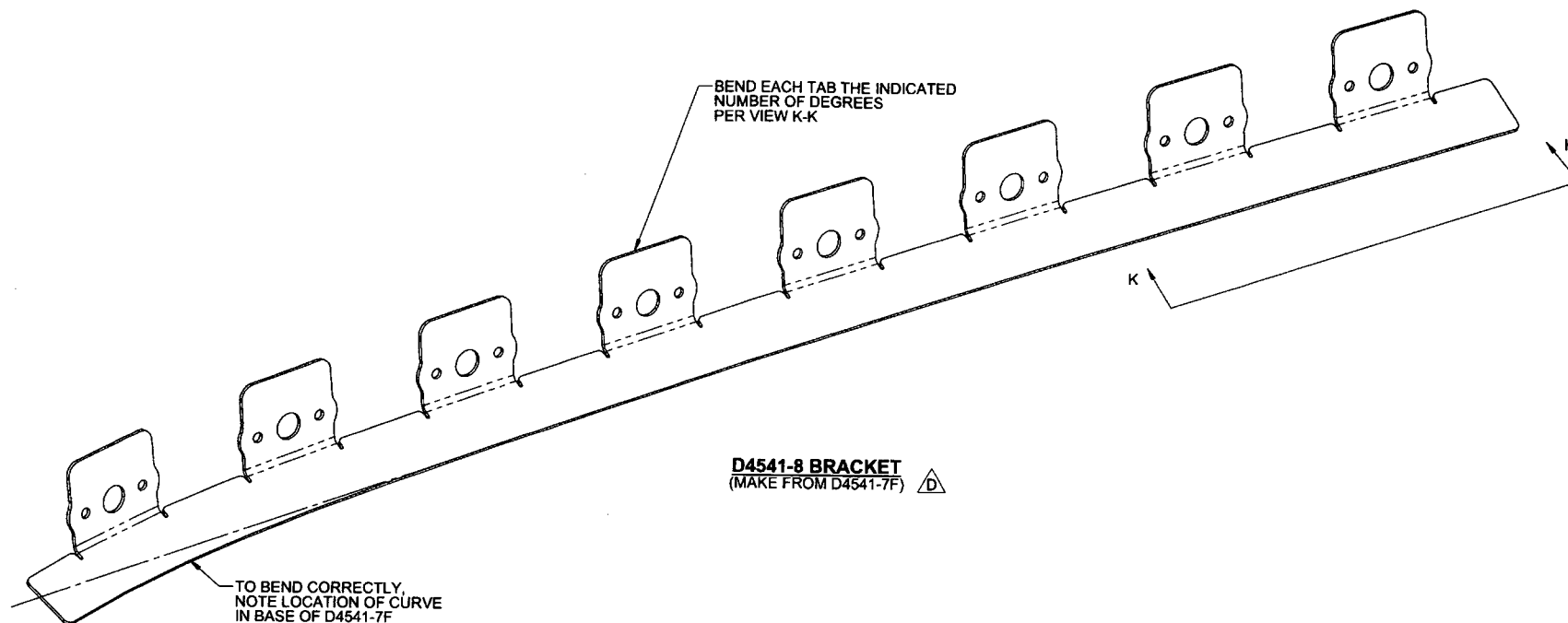
129.75317

m128054

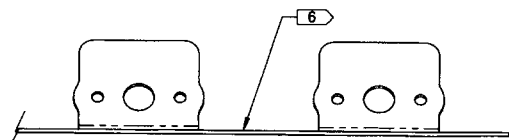
304.48

128054 → ①

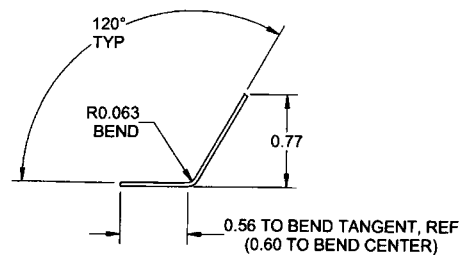




D4541-8 BRACKET
(MAKE FROM D4541-7F) $\triangle D$










VIEW K-K
BEND DETAIL
NOT TO SCALE

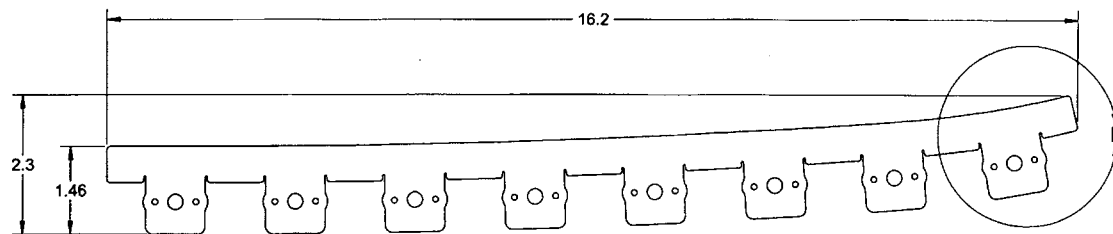


RELEASED
2013-04-22
JND

NOTES:

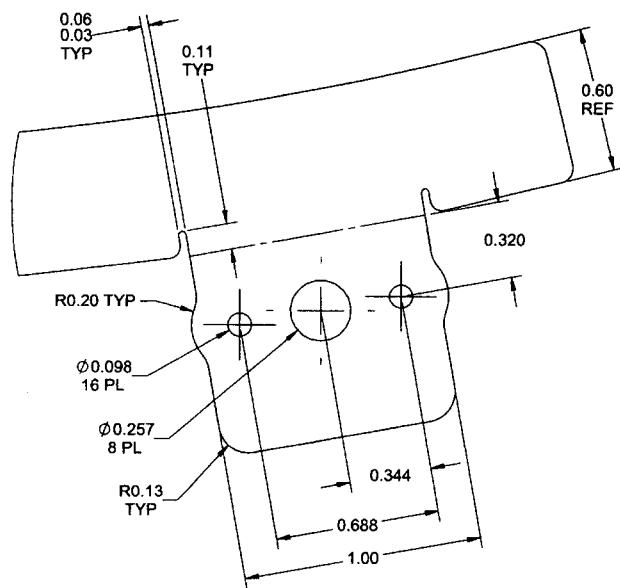
- 1) MATERIAL: MAKE FROM D4541-7F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. 
MFG. APPR.		D4541	SHEET 10 OF 
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NT
DATE	13.02.04	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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D4541-7F FLAT PATTERN

GRAIN
DIRECTION



DETAIL L
TYP TAB DETAIL
SCALE 4X

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.04 lbs
- 8) PROFILE PER DRAWING FILE "D4541-7F-REVD.DXF"

RELEASED
2013-04-22

DESIGN	gq	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	gq		
CHECKED	ASS	DRAWING NO.	REV. D
MFG. APPR.	gq	D4541	SHEET 11 OF 11
APPROVED	gq	TITLE	SCALE
DE APPR.	gq	BRACKET	NTS
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